

Work Order ID 86519 -2

July 4, 2012 7:15:17 AM

\*86519\*

Page 1

Item ID: D3916-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Rib Assembly

Start Date: 7/04/12

Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 7/06/12

Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan: CL

Date: 12/07/04

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID:

Operation

Set Up/

Tool ID

Tool #

Plan

Accept

Reject

Reject

Insp.

Work Center ID:

Description

Run Hours

Code

Qty

Qty

Number

Stamp

Draw Nbr

Revision Nbr

D3916

A

100

0.00

\*100\*

Large Fab

Large Fab

Memo

0.00

1- Cut tube 50"

2- Bend tube with manuel pipe bender as per DT9567

\*\*\* Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\*

3- Trim access tube material to finish size as per dwg D3916

4- Drill and chamfer holes as per dwg D3916-1 using DT9605

105

QC6- Inspect dimensions to drawing

0.00

\*105\*

QC

Quality Control

Memo

0.00

G SAP 12.07.04

(6x) 12.07.04



# Work Order ID 86519

July 4, 2012 7:15:17 AM

**\*86519\***

Page 2

Item ID: **D3916-041** Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Rib Assembly  
 Start Date: 7/04/12 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 7/06/12 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
107 <b>*107*</b> Large Fab	Weld per dwg A/R S.S. rod Batch: <i>M121602</i>	0.00							
Large Fab	Memo 1- weld bushing as per dwg D3916 2- grind welds flush	0.00							
110 <b>*110*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
120 <b>*120*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo	0.00							

*Sp 100 12 - 7 - 11*

*DAS 16 12/07/12*

*DAS 16 12/07/12*

*(+4)*





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**\*86519\***

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Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

**Item Name:** Rib Assembly

Start Date: 7/04/12      Start Qty: 6.00      \*6\*

Cust Item ID:

Required Date: 7/06/12      Req'd Qty: 6.00      \*6\*

**Customer:**

**Reference:**

Approvals:      Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

### Operation Description

## Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

130

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

\*130\*

### Packaging

## Memo

0.00

### Packaging

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

## Memo

0.00

### Quality Control

12/17/20

ME  
12-07-76



# Picklist Print

July 4, 2012 7:15:16 AM

Page 1

Work Order ID: 86519

Parent Item: D3916-041

Parent Item Name: Rib Assembly

Start Date: 7/04/12

Required Date: 7/06/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC  
verified by:EC

IPP Rev:B as per dwg revA 10.03.15

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1 Bushing		Manufactured	No			100	Each	170.0000	7	42			
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Location	Loc Qty	Loc Code
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WA	163	
79213	1	
83464	162	
WA005	7	
66489	1	
82785	6	

B82785 → (5)  
B83464 → (23)

M304TS0.750W.049  
304 SQ Tube .75x.75x.049W

Purchased No

100	f	185.4812	4.166	26.311579
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Location	Loc Qty	Loc Code
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MAT017	38.256337	
121898	38.256337	
MAT018	146.1623959	
119147	2	
119643	3.30639585	
121439	16.8353	
122201	124.0207	
WA034	1.0625	
121087	1.0625	

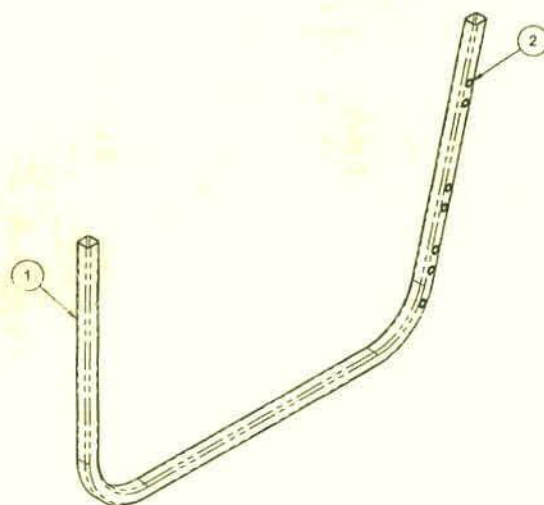
26.3116



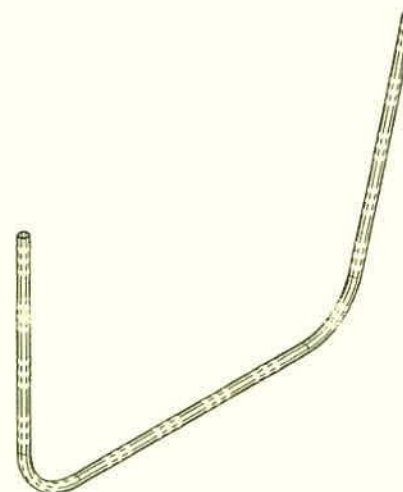




ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

CL 12/07/04  
W10: 86519

OR 10.12.21  
~~UNDER REVIEW~~

ADDITION OF HOLE + BUSHING  
ON D3916-041 RIBS.

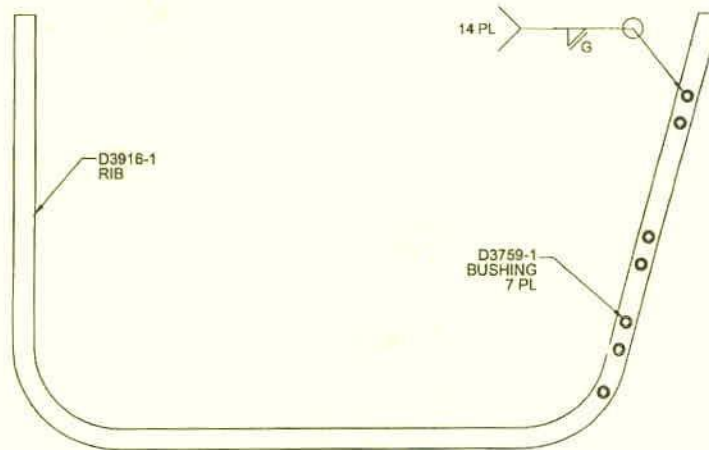
**RELEASED**

2010-03-12

MP

A		NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD			
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA			
CHECKED	[Signature]	DRAWING NO.	D3916	REV. A	
MFG. APPR.	[Signature]	TITLE	RIB ASSY, 350 BASKET	SHEET 1 OF 4	
APPROVED	[Signature]	SCALE	NTS		
DE APPR.	[Signature]	COPYRIGHT © 2010 BY DART AEROSPACE LTD			
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D3916-041 RIB ASSY

**RELEASED**  
2010-03-12  
AMP

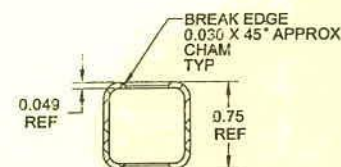
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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RELEASED  
2010-03-12

**NOTES:**  
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 1.76 lbs  
9) TUBE FLAT LENGTH 50.0 REF

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
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